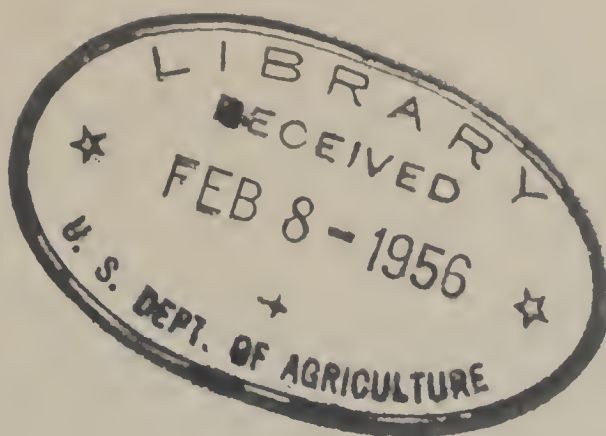


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January 1954

Supplement I to the September 1952 Edition

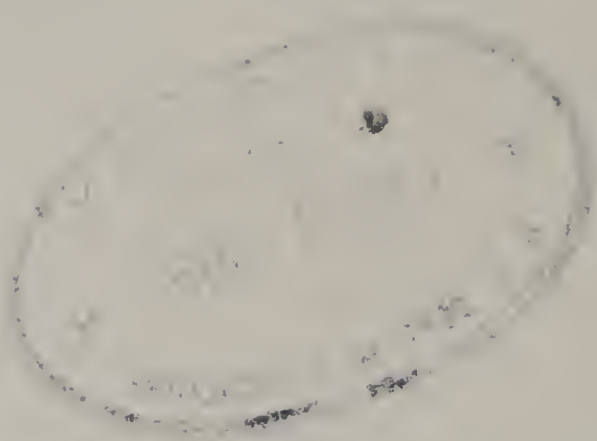
MANUAL OF INSPECTION PROCEDURES

of the

MEAT INSPECTION SERVICE

of the United States

Department of Agriculture



Section 3.1 (a) is amended to read :

3.1 (a) Meat Inspection is conducted by the Meat Inspection Branch. Meat Inspection Branch is intended wherever Meat Inspection Division appears in the Manual. All permanent employees engaged in the work of meat inspection are appointed upon certification of the United States Civil Service Commission that they have met the requirements of that Commission. These employees are classified as shown in the following paragraphs. Promotions are made on the basis of efficiency, department, and length of service.

Section 3.4 is amended to read :

3.4 In-service training of employees responsible for technical operations such as those performed by veterinary meat inspectors and meat inspectors must be built mainly around instructions received while on assigned work from the inspector in charge and others with supervisory responsibility, and in addition, from recommended reference literature and from information received through daily contacts with coworkers. Inspectors in charge, supervisors, and inspectors having supervisory responsibilities, such as "Final Inspectors," must be alert to the training needs of employees under their supervision during daily contacts with them. As conditions permit, inspectors should be afforded opportunity to work in a training capacity with experienced employees who can instruct them in the various phases of inspection work necessary to better qualify them for performance of all duties of their particular grades or for promotions as vacancies occur in a higher grade. Guides for use in training inspectors are available and should be used to assure uniform training in the conduct of inspection work at all stations.

Part 3 is amended by the addition of sections 3.13 and 3.14 :

3.13 An official set of meat inspection regulations, manual, memoranda and directory are to be maintained in each office regularly used by inspectors. The official sets of instructions should be returned to the Washington office of the Meat Inspection Branch when inspection is withdrawn from

an establishment where an official set has been maintained in the inspector's office. Requests for additional official sets of instructions should be made to the Washington office when inspection is inaugurated at an establishment where the inspector's office is used as headquarters. Under no circumstances are these official sets to be regarded or maintained as the personal property of any inspector. Each inspector must be fully informed concerning his duties and responsibilities and these are clearly outlined in the material which is included in the official set. The responsibility for current maintenance of the official set of instructions including the directory is placed with the inspector in charge.

3.14 It has long been the policy of Meat Inspection that supervisors are responsible for the safety of employees in their unit. In discharging this responsibility, supervisors should continually encourage employees to use safe working practices and equipment. Unsafe working conditions must be recognized and eliminated wherever possible.

Parts 5 and 6 are amended by the addition of sections 5.4 and 6.3, respectively:

5.4 It is imperative that inspectors in charge report immediately to the Washington office any situation at the station such as a strike, flood, fire, or the like, which might result in a work stoppage. The report shall be made by wire and contain the following information:

The date of occurrence.

The probable duration of the situation.

The number of employees affected.

The arrangements that they have made or will make to utilize the employees' services.

The work or leave status of affected employees.

State that they have contacted other USDA activities at their station and whether the services of surplus employees could be utilized by such agencies on a reimbursable basis.

The inspector in charge will then be instructed concerning the course of action which should be followed. Surplus employees should be kept on standby status until they receive instructions to the contrary.

6.3 Many inspection positions require the inspector to travel from one location to another in the performance of his duties. Very frequently public transportation is not

readily accessible or practical and it becomes necessary for the inspector to use his personally owned automobile for efficient inspection coverage.

The selection of personnel to cover the types of assignments requiring the use of an automobile, which are usually in grade GS-6 and higher, will be based on the availability of a personally owned automobile as well as the willingness of the employee to use his car on a reimbursable basis when it is found necessary to do so to cover an assignment. It is anticipated that no difficulty ordinarily will be encountered in filling the relatively small number of assignments in meat inspection requiring the use of a car by employees who have their own automobiles and are willing to use them for official purposes on a reimbursable basis.

It is recognized that occasionally the need for the use of a car may develop after an employee is already occupying a given assignment and that the particular employee might not possess a personally owned automobile or might not be willing to use it for official purposes if he does have one. If this should occur, an effort would be made to solve the problem through an exchange of assignments with another employee of the same grade at the station who is willing to use his personally owned automobile for official purposes in carrying out the assignment. If this kind of arrangement could not be worked out, the next alternative would be the transfer of the employee occupying the particular assignment requiring the use of a car to a position of the same grade level at another station where the need for the use of a car would not exist. Such transfer would be at Government expense since it would be in the interest of the service in that it would place the transferred employee in an assignment in which he could function effectively and would make it possible to fill the assignment vacated by him through the promotion of another employee willing to use his personally owned automobile for official purposes.

Section 8.2 is amended to read:

8.2 The water supply at official establishments is very important in connection with sanitation. Before the water supply is accepted incident to granting inspection at an establishment, full consideration should be given to its source and the distribution system within the plant. Water from an approved public supply may be regarded as acceptable as delivered to the establishment. When the establishment

uses a private supply, a report on the bacterial quality of supplies taken inside the plant should be required at least every six months or at any other time the inspector has reason to question its condition. Since water may become unpotable as it is distributed in the plant, the inspector should give regular attention to the condition of all storage facilities and pipe lines in the establishment. Such hazards as dead ends of pipelines, improper cross connections between potable and nonpotable water and the absence of anti-back siphonage devices should be eliminated. A report concerning potability should be required by the inspector whenever he has reason to question the condition of the water at any distribution outlet in the establishment regardless of the original source of the water supply. In cases where any establishment is permitted to use nonpotable water for certain purposes, its use must be surrounded by adequate safeguards to make sure that it cannot possibly come in contact with edible product or pollute the potable water supply. Inspectors should give constant vigilance in connection with equipment installations to assure that contamination of the potable water supply is not made possible. Inspectors in charge are expected to take such action as may be necessary to assure that only potable water from an approved supply is used in edible products departments in establishments and in areaways connected with such departments.

Section 8.6 is amended to read:

8.6 (a) Samples of insecticides and rodenticides intended for use in official establishments need not be submitted to the Washington meat inspection laboratory. It is the responsibility of inspectors to see that each preparation contains only permitted materials and that the use is in accordance with Meat Inspection requirements. Particular attention should be given materials used by exterminators to be sure that they are acceptable and correctly used. Manufacturers of these materials are required to show a list of active ingredients on the label. Insecticides and rodenticides in containers not showing this information on the label should not be accepted.

(b) The following list of permitted insecticides, rodenticides and fumigants summarizes those materials which have been approved:

Insecticides

(1) May be used in all areas and where product is handled provided exposed product is first removed and the equipment cleaned by thorough washing before operations are resumed:

Deodorized kerosene solutions of:

Pyrethrum extract.

Rotenone.

Organic thiocyanates (lethane, thanite).

Pyrethrins.

Allethrin (allyl homolog of cinerin I).

1% or less of the following synergist-insecticides, singly or in combination: Piperonyl butoxide, N-propyl isome (di-N-propyl maleate isosafrole condensate), N-octyl dicycloheptene dicarboximide (Octacide 264, Van Dyke 264, MGK 264) or sulf-oxide.

(2) Use limited to areas where exposed product is not to be handled:

Deodorized kerosene solutions of:

DDT (dichloro-diphenyl-trichloroethane).

Chlordane.

Lindane (gamma isomer of benzene hexachloride).

Methoxychlor.

More than 1% of piperonyl butoxide, N-propyl isome (di-N-propyl maleate isosafrole condensate), N-octyl dicycloheptene dicarboximide (Octacide 264, Van Dyke 264, MGK 264) or sulfoxide.

(3) The following substances when mixed with dry inert materials may be used as insect powder for the elimination of roaches, under circumstances which absolutely preclude contact with product:

Sodium fluoride (must be definitely colored green or blue).

Borax.

Boric acid.

Derris and cube roots.

Powdered pyrethrum.

Powders containing organic thiocyanates (lethane, thanite).

DDT—Insecticide powder containing DDT must not be used in any area where edible product is handled.

Rodenticides

(1) Must be used under circumstances which absolutely assure no contact with product:

Barium carbonate.

Red squill.

ANTU (alphanaphthyl thiourea).

Warfarin.

Fumigants

(1) Must be used only under supervision of licensed and experienced operator—extremely dangerous. Ventilate premises thoroughly:

Hydrocyanic acid gas.

Methyl bromide gas.

(c) The use of insecticides, rodenticides and fumigants containing materials other than those listed above should not be permitted.

(d) When proposals to use other insecticides, rodenticides or fumigants are received they should be forwarded to the Washington office for consideration. Proposals to use accepted materials in a manner other than that which has been outlined should also be forwarded to the Washington office.

(e) Because of the extremely high toxicity and physical characteristics (odorless, colorless and tasteless) of 1080 (sodium fluoroacetate), its use on the premises of official establishments has not been accepted. Compounds of arsenic, strychnine, thallium and yellow phosphorus are also not permitted due to their extreme toxicity.

Section 8.12 is amended to read:

8.12 The use of magnetic traps has demonstrated that there is significant contamination of meat with particles of iron from various sources. Samples of iron particles removed from chopped meat products by magnetic traps consist of nails, pieces of wire, pieces of flat staples of the type used to close fiber boxes, and miscellaneous small pieces of metal including bits of broken bearings, grinder plates, and washers. Therefore, the importance of constant vigilance and adequate inspection procedures to preclude the contamination of meat by foreign materials during its handling and processing must be emphasized. The magnetic trap is, of course, no substitute for such precautions. The magnetized

portion (core) of the trap is constructed of iron whereas the threaded connecting nipples are made of stainless steel. The iron portion becomes darkened after a period of use. The darkening is not objectionable but to prevent rusting of this portion, the trap should be thoroughly dried after cleaning and given a light application of paraffin oil.

Section 8.13 (c) is amended to read:

8.13 (c) Metal tag fasteners and wood and metal skewers should be completely removed from carcasses prior to cutting and boning. Tag fasteners of a design which cannot be readily removed from the meat should not be permitted.

Section 8.13 (o) is amended to read:

8.13 (o) Inspectors should assure themselves that containers and coverings for product, including metal lard drums which may have a coating on their inner surface, are acceptable for use. Slack barrels and similar containers should be carefully examined for wood splinters and lined with suitable material to avoid contamination with splinters. When paper is used to line containers, it should be of such quality that it will not disintegrate when in contact with meat and juices. All paper adhering to the outer surface of frozen blocks of meat should be removed before the blocks are cut. In some cases, copper coated staples have been used in fiber containers. When in contact with meat, these staples cause a green discoloration which should be removed prior to use of the product.

Part 8 is amended by the addition of section 8.13 (x):

8.13 (x) The construction of gate valves used on the lower openings of edible rendering tanks permits passage of a considerable amount of meat tissues, bone fragments, fats, and the like into the valve bonnet. To assure sanitary maintenance of this type of gate valve, it is essential that some method of regular (daily) flushing of the inner parts of the bonnet be available. Furthermore, the valves must be completely dismantled at such periodic intervals as found necessary for thorough cleaning and inspection. Several acceptable methods of installing openings into valve bonnets for daily flushing with hot water and/or steam have been devised. Combination steam and hot water lines may be permanently connected to the bonnets; however, if this is

done adequate precautions to prevent back-siphonage into the potable water supply are necessary. It is expected that gate valves used for the purpose described above will be provided with similar facilities for daily cleanout and a program of dismantling as often as found necessary initiated without delay.

Sections 8.17 and 8.18 are amended to read:

8.17 It has been reported that reconditioned second-hand wooden containers have been used at certain stations. Such containers cannot be given the inspection necessary to determine whether they are fit for use, as contemplated in paragraph 8.12 (a) of the Meat Inspection Regulations. Wooden containers are frequently used in industry for various chemicals such as insecticides, acids and alkalis, some of which are highly poisonous. Containers previously used to hold food may contain decomposed material consisting largely of food-spoilage organisms and their dangerous toxins. Sometimes evidence of contamination with vermin excreta is also found in used containers. Since the complete removal of dangerous substances cannot be accomplished with certainty from containers made of porous material such as wood, containers of this type which show evidence of contamination should be rejected. Of course, second-hand containers of porous material which have been reconditioned prior to receipt at the establishment should not be accepted.

The satisfactory reconditioning of second-hand containers made of nonporous material such as steel drums can be permitted without prior inspection. Inspectors should examine such containers very carefully to determine that effective cleaning and preparation for use has been accomplished. The inspection should include (1) wiping the inner surface of the container with a clean white cloth or towel to determine whether all former contents have been removed, (2) look for a spotted appearance of the inner surface which may be an indication that the new lining will not adhere properly over old linings, improperly cleaned or rusty surfaces and (3) look for dents in chime and sides of drum. These areas should be free from damage which would interfere with satisfactory cleaning and inspection. In determining the acceptability of steel drums, inspectors should apply the usual product container requirements for cleanliness and absence of probable sources of contamination. The acceptability of the coating on the inner surface of any metal

container can be determined by obtaining from the establishment the name of the lining material and name and address of the firm which applied the coating and forwarding this information to the Laboratory Section, Meat Inspection Branch, Washington, D. C.

8.18 Inspectors should give close attention to the reconditioning of wooden curing vats. After emptying, the vats should be flushed with water and removed from the curing department. All slivers, blisters, badly discolored wood and ridges should be removed from the inner surface of the vat and a smooth clean inner surface should be obtained. The outer surface of the vat should be smooth with the hoops free from corrosion. Badly rusted hoops should be replaced with new galvanized or stainless steel hoops. After the inner and outer surfaces of the vat have been properly smoothed, it should be flushed with clean water and steam to remove particles of wood and dust. A suitable truck should be used for returning the vats to the curing department since rolling the vat on the floor results in contamination of the outer surface and top of the vat.

Part 9 is amended by the addition of sections 9.10, 9.11, 9.12, and 9.13:

9.10 Ante mortem inspection of horses should include observing the animals closely at rest and in motion for action and appearance. Fistulous withers, poll evil, melanotic tumors, respiratory disturbances and cripples of various kinds are the most frequently observed abnormal conditions. Animals showing conditions which would cause condemnation on post mortem inspection and those having a rectal temperature of 105° F. or above should be condemned on ante mortem inspection. A walkway, about 36 inches above the floor and along the inside of the pen, has been found to lessen the hazard of injury to the inspector and better enable him to observe the neck and withers regions of the horses when performing ante mortem inspection.

9.11 Listerellosis or listeriosis has been reported from all sections of the country in cattle, sheep, swine and horses. The symptoms on ante mortem inspection are typical of encephalitis and may consist of weakness, fever, incoordination, circling, pushing or leaning against objects. The head may be held to one side and the ear on that side drooped; if moved, the head returns to this position. Pharyngeal pa-

ralysis is frequently observed. Animals showing symptoms of this disease should not be slaughtered.

9.12 Scrapie is a disease of sheep and goats which has been found in this country. During the early stages of the disease, no characteristic symptoms develop; however, later the animals become restless and excitable with tremors and grinding of the teeth. Pruritis is characteristic and the animal rubs against solid objects and scratches with the hind feet. Soon after this, the wool drops from the flank and hind quarters. Gradual incoordination follows and excitement may bring on convulsions and coma. This stage is followed by emaciation and weakness with the animal unable to rise; death soon follows. When animals suspected of having this condition are found, a report should immediately be made to State and Federal officials in charge of animal disease control work who will dispose of the animals affected with scrapie.

9.13 The importance of the detection of vesicular conditions in hogs on ante mortem inspection cannot be overemphasized. It is only when a vesicular condition is identified and reported in the live animal that a differential diagnosis of the vesicular condition can be readily made. Inspectors performing ante mortem inspection on hogs should take whatever steps are necessary to assure that no animals affected with a vesicular condition escape detection. Since lameness of the animals is one of the most prominent symptoms, there should be little difficulty in identifying such animals by having the lots of animals moved or presented for inspection in such a manner that any lameness would be observed. Inspectors should take plenty of time to observe lots of hogs on ante mortem inspection and require necessary facilities such as adequate lighting and pen conditions for the thorough type of examination which is expected.

In addition to lameness, characteristic vesicles may be observed on the feet around the coronary bands, interdigital spaces and the foot pads near the dew claws. The entire foot pad may eventually slough off, the posterior edge coming loose first. Vesicles may also be seen on the snout, lips, oral mucosa and tongue with considerable variance in size. There is an early rise in temperature which persists until the vesicles have ruptured when it rapidly returns to normal. Secondary infection may appear at the location of the vesicles and other infection such as pneumonia and enteritis may follow. All instructions for ante mortem and post mor-

tem dispositions of animals affected with this condition will be found in Sections 9.18 and 11.34, respectively, of the Meat Inspection Regulations.

When hogs are present in excess of the number which will be slaughtered on the day of ante mortem inspection, careful daily inspection of all slaughter animals in the pens owned or leased by the establishment should be made. Such examination will be helpful in enabling the inspector to know the general condition of hogs which will later be subjected to thorough ante mortem inspection on the day of slaughter. When any vesicular condition is observed, the matter should immediately be reported by telephone to Federal and State officials in charge of animal disease control who will make a diagnosis, and instruct you and the plant management concerning procedures that must be followed.

Section 10.11 (a) (10) is amended to read:

10.11 (a) (10) All parts of the viscera should be inspected when removed from the carcass. To facilitate the examination, repeated incisions should be made of the right and left bronchial lymph glands, the medial and posterior mediastinal lymph glands, and the portal lymph glands. The heart should be opened and examined as directed in section 11.24 of the Regulations. Examination of the liver should include opening the large bile duct. This should be done very carefully as cutting through the duct into the liver tissue will interfere with the detection of the small lancet liver fluke. The incision should extend at least an inch through the bile duct dorsally and in the other direction as far as possible. The lungs and liver should be palpated for the purpose of detecting any abnormal condition, whether located superficially or deeply in the organ. The mesenteric lymph glands, the paunch, and the spleen should be examined and incised if necessary. The junction of the rumen (paunch) with the reticulum (honeycomb) should be carefully palpated to determine whether there are abscesses present at this point.

Section 10.11 (b) (1) is amended to read:

10.11 (b) (1) Inspectors assigned to head inspection are required to inspect the hog carcasses to determine whether they have been properly cleaned. The establishment has the responsibility for properly cleaning hog carcasses before any

opening is made for evisceration or dropping the head. Inspectors can assist the managements of establishments in assuming this responsibility by pointing out many of the factors which influence satisfactory scalding, dehairing and cleaning. Some of these factors are circulation, water temperature, number of carcasses and time carcasses remain in the scalding tub; condition and operation of the dehairing machine including the water temperature and number of carcasses through the machine. These factors may vary considerably in different installations and with the type of hogs slaughtered; however, when given adequate attention, there should be no difficulty in obtaining satisfactorily cleaned carcasses. The knife used to partly sever the head should be sterilized after each head is dropped. The carcass should be presented to the head inspector in such a way as to make the cervical lymph glands readily available for inspection.

Part 10 is amended by the addition of Section 10.11 (b) (11) :

10.11 (b) (11) The necks of hog carcasses should be washed, after removal of the leaf and scrap fat, to remove ingesta, hair, scurf and blood clots from the sticking wound area. The skimmings from the tank receiving water from neck washing shall not be used for edible purposes.

Part 10 is amended by the addition of section 10.11 (e) :

(e) *Horses*

(1) Loose hair can be controlled by spraying the bellies, legs and feet with water prior to slaughter. Adequate measures should be taken to prevent the contamination of carcasses and viscera with urine. Hide removal should be accomplished without the carcass contacting the floor or other fixed objects. The evisceration and splitting operation should be performed in such a manner that the carcass does not contact the floor.

(2) *Cervical inspection*: The head, identified with the carcass by duplicate numbered tags, should be removed immediately after skinning. All hide and external ear canals should be excised prior to thorough washing and flushing of the nasal and oral cavities. Following this, the head should be placed on the inspection rack. The inspection should include a general visual examination of the head for cleanliness, palpation of the submaxillary and pharyngeal lymph glands and guttural pouch with incision of the parts when

necessary to determine the nature and extent of any abnormality. The nasal septum and turbinate bones should be exposed and given careful examination. This can be accomplished by using one of the following methods or another method found to be satisfactory: (1) Split the head lengthwise and cut the septum from its attachments or (2) cut through the nasal bones transversely with a cleaver at a point in line with the anterior end of the facial crest and pull the nasal bones downward. The purpose of this inspection is primarily to detect glanders but polypi, rhinitis and sinusitis are also revealed. Horse tongues should be examined for tooth lacerations which must be excised. The dark stain frequently seen on the dorsal surface of horse tongues should be removed by excision. The muscles of mastication need not be incised for examination.

(3) *Viscera inspection*: Viscera should be placed in the usual type inspection truck for examination. Palpate the bronchial and mediastinal lymph glands and lungs and incise when abnormal conditions are found. The heart should be incised as for cattle and examined for endocarditis and melanosis. Palpate the portal lymph gland, liver and spleen. Examine the liver carefully on both surfaces. Open the bile duct as for cattle in an examination for flukes. The rest of the viscera and body cavities should be carefully observed for any abnormality. When horse lungs are prepared as edible product, the usual inspection for foreign material in the bronchi should be given.

(4) *Rail inspection*: Palpate the body lymph glands and observe the carcass for abnormality. Encysted parasites may be found under the peritoneum on the inner abdominal walls. The spinous processes of the thoracic vertebrae in the withers region should be removed and this area as well as the poll carefully examined for fistula. Removal of the first two cervical vertebrae facilitates inspection of the poll area. Equipment used in splitting or cutting the withers and poll regions should be sterilized after each use. The examination for melanosis should be conducted carefully, giving particular attention to the axillary and subscapular space in white or grey horses or when melanosis is found elsewhere. Obviously, this requires that such areas be exposed to view by removing the overlying tissues (dropping the shoulder). The fat and tissues lining the pelvic cavity should be given careful attention, especially along the femoral artery in white and grey horses.

Part 10 is amended by the addition of section 10.14:

10.14 Inspectors should give special attention to assure that contamination of carcasses and parts does not occur when fountain-type brushes are used for washing. The use of this type of equipment has been found to frequently result in the transfer of objectional material from one carcass to another.

Section 11.7 is amended to read:

11.7 When a lesion of tuberculosis or one resembling that disease is found by a veterinary meat inspector in the post mortem examination of a non-reactor beef type animal a specimen of the lesion should be sent to the Pathological Laboratory serving his area. One copy of Form TE-35 should accompany Form M-4 and the specimen when forwarded to the laboratory. One copy of each Form M-4 and TE-35 should be forwarded to the Federal veterinarian in charge of the State concerned. One copy of Form TE-35 should also be sent to the Animal Disease Eradication Branch, Agricultural Research Service, U. S. Department of Agriculture, Washington 25, D. C.

After examining the specimen, the pathologist will send copies of his findings to the meat inspection station from which the specimen was received and to the Federal veterinarian in charge of the State identified on Form TE-35 as the origin of the animal.

Part 11 is amended by the addition of sections 11.15, 11.16, and 11.17:

11.15 Animals which are known to have recovered from listerellosis may be slaughtered as suspects. If found free from disease conditions which would require other disposition, the carcass and viscera may be passed for food but the head should be condemned.

11.16 In preparing Form MI 403, "Ante Mortem and Post Mortem Inspection Summary", the actual slaughtering time for the species involved should be recorded by the final inspector in the block where he signs the form. A statement such as "5 hours" will be sufficient.

11.17 Hogs affected with atrophic rhinitis may be identified by a characteristic disfiguration of the nose and complete or almost complete absence of the nasal turbinate bones. Small amounts of pus or catarrhal exudate may be found in the nasal sinuses. The soft tissues of the turbinates may be

present but folded against the nasal cavity wall, since the supporting bony structures have disappeared. Abscesses or caseous necrotic lung lesions which are well circumscribed have been found in old cases and are probably due to inhalation of tissue particles or exudate from the nose during the active stage of the disease. This condition is usually localized and the tissues of the head which are used for food can be removed without contamination.

Section 14.2 is amended to read:

14.2 It is not practical to require that contents of tanks be cooked a certain length of time to render them unfit for food purposes, because of the varied types of equipment, kind and quantity of contents, heating processes, and the like. The use of equipment such as crushers or hashers for pretanking preparation of condemned carcasses, parts, and viscera in the inedible products departments of most establishments has been found to give inedible character and appearance to the material. The use of washing equipment in connection with hashers for viscera does not affect this determination. In establishments using such equipment, the inspection supervision of condemned carcasses and product shall be maintained only until this material is crushed or hashed. Inspectors shall give the usual supervision to obtain prompt and sanitary handling of the crushed or hashed material like all other inedible materials in the inedible rendering department. Conveying systems, rendering tanks, and other equipment used in the further handling of the crushed or hashed material will not need to be sealed or locked. In cases where rendering tanks contain condemned material treated as outlined above, as well as condemned material not so treated, the tanks shall be sealed until all of the contents are destroyed for food purposes. If the condemned material is not rendered in the establishment where produced, sufficient crude carbolic acid or cresylic disinfectant shall be added to it at the time of crushing or hashing to positively preclude the use of the material for food purposes after removal from the establishment.

Section 16.10 is amended to read:

16.10 The legibility of the marks of inspection has been improved in some cases by drilling two small holes (about one-sixteenth inch in diameter) through the face of the hot-

iron brands to permit the escape of steam that forms when the hot brand comes in contact with the wet surface of product. The use of cast steel burning brands has been found to result in improved and more legible inspection legend imprints on cured products.

Sections 16.12 and 16.14 are amended to read:

16.12 A hot ink brand equipped with a thermostatic control to regulate the temperature of the electrically heated burning element has been found to greatly improve branding on meat, meat byproducts and meat food products. Ink for hot brands may be prepared without sugar using an acceptable dye and specially denatured alcohol 23A (alcohol plus 10 percent of acetone) if desired.

16.14 Official grading terms such as Prime, Choice, Good, Commercial, and Utility, and the letters AA, A, B, and C which are associated with these official grades of meat of cattle, sheep and calves, may be used in official establishments only on meat which is graded as such by an official representative of the Federal Meat Grading service.

Wholesale and retail cuts derived from carcasses bearing an official grade designation may be identified with the same grade designation as appears on the respective carcass from which the cut is derived.

These instructions do not apply to the terms "Army-AA," "Army-A," "Army-B," or similar terms applied to meats or the package thereof in conjunction with the standard Army veterinary inspection stamp by inspectors of the United States Army.

Part 16 is amended by deleting section 16.42.

Section 17.11 is amended to read:

17.11 An inspector can readily see ink that has become transferred to the product, or a label that has disintegrated or corroded. But he faces a somewhat different problem with substances used in the manufacture of plastics and paper coatings. Generally, manufacturers of plastic films, coatings and containers present to the Laboratory Section, Washington office, samples of their materials and a statement of their composition in order to have their acceptability determined before making deliveries to inspected establishments. If the inspector has a question concerning the acceptability of such materials, he should send a sample of the

material, with all identifying marks, the name and address of the manufacturer, and any other pertinent information, to the Laboratory Section, Washington office, for advice. Aluminum foil (containing no lead) is acceptable from a toxicity standpoint for use in direct contact with product, although when in contact with well salted product corrosion may take place to an extent that would make its use undesirable.

Section 17.18 is amended by the addition of paragraph (f) :

(f) When dehydrated celery, dehydrated garlic or dehydrated onions are used as seasoning agents for meat or meat food products, their presence may be reflected in the statement of ingredients on labeling material as "celery," "garlic," or "onions" as the case may be.

Section 17.27 is amended to read :

17.27 It has not been required that meat and meat food products in casings be marked with a statement of quantity of contents; however, no objection is offered to providing on the casing space for applying the weight such as an opaque area preceded by the words "Net Weight." The presence of such facilities should not be construed to mean that the weight must be shown before the product leaves the establishment. However, if the casings are marked with a statement of quantity of contents, the inspector should check to see that such statements are accurate.

A new merchandising-practice has developed in the industry which consists of enclosing products such as ring bologna, ring liverwurst, pepperoni and salami in plastic film bags. Such packages are required to bear a label showing all of the required features of a trade label, including a statement of quantity of contents.

Section 17.49 is amended to read :

17.49 The term "refined lard" is applied to open-kettle rendered, prime-steam, or dry-rendered lard that has been run through a filter press with or without the addition of a bleaching agent.

Section 18.50 is deleted and the following is substituted therefor :

18.50 Temperaturing devices, including thermocouples

and various types of thermometers, are frequently available at official establishments for taking temperatures of product during processing. Inspectors may make use of any such temperaturing devices in their inspection work, providing they have been checked adequately against an official thermometer to insure accuracy and dependability. When distant reading devices such as thermocouples are used for temperaturing product, the sensitive element must be placed in the coldest part of the product just as is presently done with thermometers.

Section 18.62 (b) (1) is amended to read:

18.62 (b) (1) Have a thorough knowledge of the formulas and manufacturing processes used in preparing each product. To obtain this information it is expected that the inspector will observe the formulation of the product and manufacturing processes sufficiently to become thoroughly familiar with the practices used by the establishment.

Section 18.64 (e) is amended to read:

18.64 (e) All procedures in sampling should be so carried out as to provide the laboratory with as representative a sample as is possible under practical operating conditions. Since there is no practical method of sampling which can be considered entirely free from the potential of error, the inspector must evaluate the report he receives from the laboratory with full recognition of this possibility of error. There is bound to be a range in moisture content through a production of a batch of cooked sausage and instances where dried skim milk or cereal has not been uniformly distributed through the product have occurred. It is not probable that any one sampling by an inspector of a batch of product will truly represent the entire production of that particular kind of sausage. The inspector, therefore, must make allowances for such probability. Naturally, a laboratory report indicating a sample of cooked sausage to contain an amount of moisture, cereal or dried skim milk considerably in excess of the regulations limitation should be interpreted as a clear indication that the plant's production methods are faulty and immediate correction should be required. By contrast with this, when sample reports show the presence of excessive added moisture, cereal or dried skim milk within narrow limits, the inspector may consider it necessary to obtain addi-

tional sample analyses of the sausage before he decides whether or not the methods used by the establishment are productive of cooked sausage that conforms with the regulations.

Section 18.69 is amended by deleting Albert Lea, Minn. under Area 3; Lake Odessa, Mich. under Area 4; Amarillo, Tex. under Area 7 and Columbus, Ga. under Area 8, and adding Archbold, Ohio under Area 4 and Shreveport, La. under Area 7.

Section 22.3 is amended to read:

22.3 Form TE-35, "Slaughtered Animals Infected with Tuberculosis," should be used for reporting animals found on post mortem inspection to be infected with tuberculosis. Instructions for the distribution of the completed report are printed at the bottom of the form. In addition to these instructions, one copy should be forwarded to the Animal Disease Eradication Branch, U. S. Department of Agriculture, Washington 25, D. C. Because of the difficulty, and in some cases considerable expense, of rounding up herds of range cattle for testing, it is desirable that occurrences of tuberculosis reported by veterinary meat inspectors on Form TE-35 when involving non-reactor beef type animals be confirmed by laboratory diagnosis before action is taken by members of the field organization of the Animal Disease Eradication Branch.

Part 22 is amended by the addition of sections 22.13 and 22.14:

22.13 The broker, commission agent, packer or other responsible person concerned with the importation has the responsibility to notify the inspector in charge when the Canadian cattle are received at an official establishment and to identify the cattle to the inspector concerned. After the imported cattle have been slaughtered, notification to that effect should be sent to the Animal Quarantine Branch inspector in charge at the border point of entry on a form supplied for this purpose, IQ-33 "Animals Imported for Immediate Slaughter." It is not expected that this coverage will be extended to plants not operating under Federal meat inspection. It should be noted that a space is provided on Form IQ-33 for indicating tuberculous lesions found in such

animals. Tuberculous lesions found in cattle from Canada should not be reported on Form TE-35.

22.14 The Animal Quarantine Branch administers certain regulations which deal with the cleaning and disinfection of vehicles which have been used to transport reactors or other animals affected with contagious diseases. At those stations where the inspector in charge has been given responsibility for administering these regulations, this should be done in the usual manner. It is not contemplated that other meat inspection employees will take any action on the disinfection of such vehicles at other locations.

Part 24 is amended by the addition of sections 24.12 and 24.13:

24.12 The importation into Canada of any swine, uncooked pork, uncooked pork products, uncooked pork offal and garbage from the United States is prohibited. This also includes hog casings. The prohibition is due to the existence in this country of vesicular exanthema.

The prohibition does not extend to boneless pork products heated to an internal temperature of at least 156° F. momentarily, or 145° F. for 15 minutes. Neither does the prohibition extend to pork products containing bone heated to an internal temperature of at least 156° F. for 15 minutes.

On the regular export meat inspection certificate covering the exportation to Canada of such cooked pork products, there should be placed on the reverse a statement certifying to the degree of heat obtained internally and to the length of time maintained. This statement should be followed by the signature and title of the one issuing the certificate.

24.13 To the regular export meat inspection certificate covering fresh, frozen, cured and/or smoked meat exported to Jamaica should be added by typewriter or otherwise the following statement: "The United States is free from foot and mouth disease."

Section 25.4 is amended to read:

25.4 Regulations covering the interstate movement of meat and meat food products via parcel post are written in section 35.20 of the Postal Laws and Regulations. It is usually helpful when dealing with a postmaster to make reference to his guiding regulations as well as the applicable provisions of the meat inspection regulations.

Section 25.11 is amended to read:

25.11 Tank cars of inspected and passed rendered animal fat moving between official establishments shall be marked as outlined in section 16.16 of the regulations.

Sections 27.7 and 27.9 are amended to read:

27.7 It is very important that a thorough and comprehensive examination be made of product offered for importation so that only that which meets the requirements is eligible for entry as U. S. inspected and passed product. Foreign canned, shelfsize hams (less than three pounds) are products that fall in a special category. The import inspection procedure differs from that followed with usually stable products such as canned corned beef, canned roast beef parboiled and steam-roasted, and the like. They are also handled differently from the "Perishable, Keep Under Refrigeration" type of product. It is a requirement that shelfsize canned hams be processed for a sufficient period of time and at a high enough temperature to make them stable. To determine this, it has been found necessary to incubate samples from each lot. It is required that the importer arrange for the incubation which should be at a place that is suitable as well as satisfactory to the inspector in charge. The initial sample inspection of 5 to 10 percent should reveal less than one-quarter of one percent unsound and/or suspicious cans. If this is so, then there is incubated one case which is usually twenty-three cans after one has been used for sample purposes. Should suspicious or unsound can or cans develop upon incubation, a detailed report should be furnished the Washington office. You will then be instructed whether further action is to be taken or whether the lot should be refused entry.

27.9 Special reports are requested for importations of cured meat the destination of which is restricted to establishments maintained under Federal meat inspection because foot-and-mouth disease or rinderpest is present in the country of origin. Information from the U. S. Customs Service is to the effect that in many cases in which some of the meat is refused entry or is condemned, this amount takes a different rate of duty from the amount passed for entry, depending on how the meat is disposed of.

Accordingly, when there are any entries in the "refused entry and/or condemned" columns on Form MI-410-2 (formerly 109J), the disposition of the meat should be given by

adding to the form one or all of the statements below as the case may be:

Converted to tankage----- pounds
 Destroyed ----- pounds
 Exported to----- pounds

If the second statement is used, indicate the method of destruction such as "destroyed by incineration." If the third statement is used, give the name of the country to which the meat is exported, for example, "exported to Mexico." Naturally, none of the statements need be added if all of the meat is passed for entry.

The Customs Service has furnished information that sometimes inspectors have failed to report the disposition of product following import inspection. In some cases, the entries have been nearly a year old. Close attention should be given to sending the duplicate copy of MI Form 410-2 to the Collector of Customs at the port of entry without delay. The instructions on the footnote of the form and in section 27.15 of the Meat Inspection Regulations should be closely observed.

Section 27.13 is amended to read:

27.13 Five copies of the Form M. I. 422-2 will be prepared at the station for each sample of imported product. The form should bear a statement indicating whether a copy of an approved label is on file at the station. The original and three copies will be forwarded with the sample, one copy being attached to the sample by whatever means are most appropriate. The fifth copy will be retained in the station file. When the laboratory findings are completed, they shall be reported on three of the copies received from the station with the sample. The original shall be returned to the inspector in charge, one copy shall be forwarded to the Special Projects Section in Washington, D. C., and another copy shall be retained by the laboratory for an office record.

When the sample is not passed by the laboratory because it does not comply with some regulatory requirement, the fourth copy will be utilized by the chemist in charge; otherwise it may be discarded. He will in such cases be returning to the station two copies showing the laboratory findings. If there is not sufficient space on the face of the form for this, the top part of the reverse side of the form may be used.

The inspector at the station will show the disposition made of the product on the reverse side of the forms and will send one copy to the Special Projects Section in Washington, D. C., retaining the other for the station file.

Sections 27.16 and 27.17 are amended to read:

27.16 (a) The form and substance of the meat inspection certificates of the following foreign countries have been approved as conforming to requirements of sections 27.6 (e) and (f) of the meat inspection regulations. Such certificates are acceptable to cover importations of meat and meat food products from these countries regardless of whose signature appears on the certificates. Unless otherwise indicated, the certificates comply with section 27.6 (e):

Argentina	Ireland (Eire)
Australia	Italy
Belgium	Madagascar
Brazil	Mexico
Canada	Netherlands
Cuba	New Zealand
Czechoslovakia	Northern Ireland
Denmark	Norway
Dominican Republic	Paraguay
England and Wales	Poland
Finland	Scotland
France	Spain
Germany (Federal Republic)	Sweden
Honduras	Uruguay
Iceland	

The foreign meat-inspection certificate is to be forwarded to the Washington office with the original of completed Form M. I. 410-2 (formerly 109-J).

(b) Meat-inspection certificates from Poland and Czechoslovakia should be authenticated by an American Consul or Vice Consul to be acceptable. The form of authentication is given below:

 ----- } SS: (venue).

I, (name of authenticating officer), (title), duly commissioned and qualified, do hereby certify that (name of officer) signing (name of country) meat inspection certificate, has

been declared by competent (name of country) authorities to have been, at the time he signed the annexed certificate, (title of meat inspector), fully competent to sign and assume responsibility for such a certificate.

In Witness Whereof I have hereunto set my hand and affixed the seal of the (title of American mission) at (place) this ----- day of -----, 19 --.

(Signature of officer)
(Official title of officer)

* * * * *

* * * * *

* * * * *

Service No. -----

Item No. 38, no fee

27.17 Amended by the addition of a facsimile of approved foreign meat inspection certificate (Ireland) and substitution of those appearing on pages 143, 149, 150, 151, 152, 156, 162, and 163.

HONDURAS



SECRETARIA DE ESTADO EN EL DESPACHO DE AGRICULTURA
REPUBLICA DE HONDURAS, C. A.

SERVICIO VETERINARIO DEL ESTADO

Place _____

Date _____

This is to certify that the meat or meat food products herein described were derived from animals which received ante-mortem and post-mortem veterinary inspection at the time of slaughter, and that said meat and meat food products are sound, healthful, wholesome and otherwise fit for human food, and have not been treated with and do not contain any preservative, coloring matter, or other substance not permitted by the Meat and Canned Foods Decree and Regulations, and have been handled only in a sanitary manner in this country.

Se certifica por el presente, que la carne o producto comestible de carne aquí descrito, derivan de animales que recibieron inspección veterinaria ante-mortem y post-mortem al tiempo de sacrificarse; y que dicha carne y producto comestible de carne son buenos, sanos y apropiados para el consumo humano; y que no han sido tratados ni contienen ningún preservativo; sustancias colorantes u otras sustancias prohibidas por el Acuerdo de la Reglamentación para la Industrialización Sanitaria de la Carne; y que han sido manipulados en forma sanitaria en este país.

[illegible]

Identification Marks on Meats and Packages .. (Marcas de Identificación de la Carne y Eultos)

Steamer S. S.
(Vapor)

Consignor
(Embarcador)

Address:
(Dirección)

Consignee
(Consignatarios)Destination
(Destino)

Shipping Marks (Marcas de Embarque)

Veterinary Authorized by the Secretary of Agriculture.
(Veterinario Autorizado por la Secretaría de Agricultura)

MEXICO

Forma Num. 15



Certificado No. _____

REPUBLICA MEXICANA
SECRETARIA DE AGRICULTURA Y GANADERIA
DIRECCION GENERAL DE GANADERIA

EXPORTACION A: _____

CERTIFICADO
DE INSPECCION DE CARNE Y SUS DERIVADOS COMESTIBLES

(LUGAR)

(FECHA)

Se certifica que la carne y derivados comestibles de la misma, detallados en este Certificado, proceden de animales que han sido sometidos a inspección sanitaria veterinaria federal, antes, durante y después de sacrificados, en los términos de la Ley de 31 de diciembre de 1949, y que dicha carne y derivados alimenticios han sido encontrados en perfectas condiciones higiénicas y buenos en absoluto para el consumo humano. Se certifica también que no contienen ni han sido tratados con ningún preservativo, materia colorante, ni otras sustancias prohibidas por la Ley antes citada.

MARCAS DE IDENTIFICACION EN LAS CARNES O BULTOS	
Nombre del Establecimiento T.I.F. Productor:	Via:
Número de Registro:	Destino:
Remitente:	Consignatario:
Procedencia:	Marcas de Embarque:
Detalle del Cargamento:	

(Firma del Funcionario Federal autorizando)

(Sello de la Direc. Gen. de Ganaderia)

THE NETHERLANDS

Serie A A



KINGDOM OF THE NETHERLANDS
MINISTRY OF AGRICULTURE, FISHERIES AND FOOD
VETERINARY SERVICES.

OFFICIAL MEAT INSPECTION CERTIFICATE OF COUNTRY OF SLAUGHTER.

Place: _____ Date: _____

I hereby certify that the meat and meat food products herein described were derived from cattle, sheep, swine or goats which received ante-mortem and post-mortem veterinary inspection at the time of slaughter and that such meat and meat food products are sound, healthful, wholesome and otherwise fit for human food and have not been treated with, and do not contain any preservative, colouring matter, or other substance not permitted by the regulations governing the meat inspection of the United States Department of Agriculture, filed with me, and that said meat and meat food products have been handled only in a sanitary manner in this country.

Kind of product: _____ Number of pieces and packages: _____ Weight: _____

Identification marks on meats and packages: _____

Consignor: _____

Address: _____

Consignee: _____

Destination: _____

Shipping marks: _____

Signature

VETERINARY OFFICER AUTHORIZED BY THE
MINISTRY OF AGRICULTURE, FOOD AND FISHERIES

Serie A



KINGDOM OF THE NETHERLANDS
MINISTRY OF AGRICULTURE, FISHERIES AND FOOD
VETERINARY SERVICES.

OFFICIAL MEAT-INSPECTION CERTIFICATE FOR PORK AND PORK PRODUCTS

(For shipment to the United States of articles of a kind prepared customarily to be eaten without cooking, which contain muscle tissue of pork.)

Place: _____ Date: _____

I hereby certify that the article or articles herein described are of a kind prepared customarily to be eaten without cooking, and contain muscle tissue of pork which, when fresh or freshly cured in salt, were subjected to a temperature not higher than five (5) degree F. for not less than twenty (20) days or otherwise treated as specified by the Chief of the Meat Inspection Division, and that said articles contain no muscle tissue of pork which has not been treated as herein specified.

Kind of product: _____ Number of pieces and packages: _____ Weight: _____

Identification marks on meats and packages: _____

Consignor: _____

Address: _____

Consignee: _____

Destination: _____

Shipping marks: _____

VETERINARY OFFICER AUTHORIZED BY THE
MINISTRY OF AGRICULTURE, FOOD AND FISHERIES.

L. (A.M.)
Ag. 198.



DEPARTMENT OF AGRICULTURE

OFFICIAL MEAT — INSPECTION CERTIFICATE

....., New Zealand,

....., 19

I HEREBY certify that the meat ^{and} _{or} meat food-products hereunder described ^{was} _{were} derived from animals subjected to ante- and post-mortem veterinary inspection at the time of slaughter and found to be free from disease and suitable in every way for human consumption and that ^{it has not} _{they have not} been treated with chemical preservatives or other foreign substances injurious to health.

Kind of Product.	Number of Parcels.	Brand or Mark.	Where slaughtered.	Consignor.	Consignee.

Signature :
Veterinary Officer, New Zealand Government.

POLAND



POLSKA RZECZPOSPOLITA LUDOWA
MINISTERSTWO ROLNICTWA
 CENTRALNY ZARZĄD WETERYNARII

ZAGRANICZNE URZĘDOWE ŚWIADECTWO BADANIA MIESA

Nr

Miejscowość

Data

Zaświadczam niniejszym, że mięsa i przetwory mięsne niżej opisane, pochodzą z bydła rogatego, owiec, świń i kóz, poddanych przed ubojem i po ubaju badaniu weterynaryjnemu oraz że to mięsa i przetwory mięsne są zdrowe, nieszkodliwe i odpowiednio spożycia przez ludzi, jak również, że do ich wyrobu nie były używane i nie są w nich zawarte żadne środki konserwujące, ani barwniki, ani inne substancje niedozwolane przez przepisy normujące sposób badania mięsa, wydane przez Departament Rolnictwa Stanów Zjednoczonych, jako też, że mięso to oraz przetwory mięsne zostały przygotowane tutaj w kraju w sposób zgodny z wymogami higieny.

Rodzaj przetworów

Ilość sztuk lub paczek (skrzyń)

Waga

Znaki rozpoznawcze na przetworach mięsnych lub paczkach (skrzyniach)

Nadawca

Adres

Odbiorca

Miejsce przeznaczenia

Znaki transportowe

Podpis

 Nazwisko urzędnika upoważnionego do wystawiania świadectw
 (badania mięsa i przetworów mięsnych wywożonych do U. S. A.)

Tytuł urzędowy

URUGUAY

Fórmula 104
M. 13-77

Corresp onde a un sellado
de cincuenta cts. (\$ 0.50)



No.

REPUBLICA ORIENTAL DEL URUGUAY
MINISTERIO DE GANADERIA Y AGRICULTURA
DIRECCION DE GANADERIA
Sección: INDUSTRIA ANIMAL

Certificado Oficial de Inspección de Carnes
(PARA ENVIO DIRECTO A)

Montevideo,

N.

Certifico que la carna y demás productos alimenticios de origen animal que se indican a continuación, provienen de vacunos, ovinos, porcinos o cabrios que recibieron inspección veterinaria ante-mortem y post-mortem al ser sacrificados, y que dicha carne y demás productos alimenticios de origen animal, son sanos, salubres y en toda forma aptos para alimentación humana, no habiendo sido tratada ni conteniendo preservativo alguno, materias colorantes u otras substancias no permitidas por las disposiciones del Departamento de Agricultura de..... que rigen la inspección de carnes, así como que dichas carnes y demás productos de origen animal han sido elaborados en este País en condiciones sanitarias.

CLASE DE PRODUCTO	No. DE PIEZAS	PESO
.....
.....
.....
.....
.....

Observaciones:

Sello de identificación de las carnes y piezas:

Remitente Dirección

Consignatario Destino

Marca de Embarque Vapor

Firma: Firma:

Título Oficial: Título Oficial:

NTA: - Este certificado deberá acompañar el cargamento de carna y demás productos alimenticios de origen animal que en el se indican, exportados a del país de donde fueron sacrificados los animales, sin descargar en ningún otro país, con excepción de la transferencia del cargamento de un conductor a otro en el transcurso del transporte, y será entregado por el consignatario o su agente al Inspector del Departamento de Agricultura en el punto de inspección de.....

El cargador de la consignación deberá suministrar la siguiente información:

Cargado el día en a bordo de

Y si hubiera descargado en cualquier punto con anterioridad a la llegada a

Descargado el día en por

y vuelto a cargar el día a bordo de por

Firma del agente o empleado del cargador)

IRELAND



DEPARTMENT OF AGRICULTURE, IRELAND.

Meat Inspection Certificate

PlaceIreland. Date

I hereby certify that the meat and meat food products described below were derived from cattle, sheep or swine, which received ante-mortem and post-mortem veterinary inspections at the time of slaughter and are sound, healthful, wholesome and otherwise fit for human food and have not been treated with and do not contain any prohibited preservative or colouring matter and that the meat and meat food products have been handled only in a sanitary manner in this country.

Kind of Product	Number of Pieces or Packages	Weight
.....
.....
.....
.....

Date of Shipment :

Consignor :

Address :

Consignee :

Address :

Shipping Marks

Identification Marks :

OFFICIAL INSPECTION STAMP.

(Signature)M.R.C.V.S.

Official Title.....

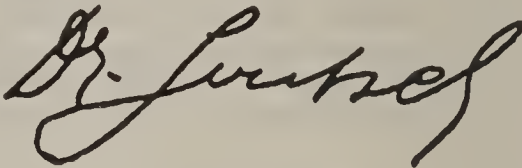
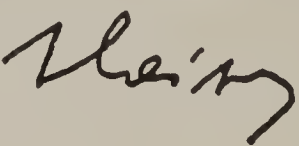
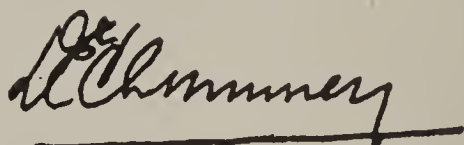
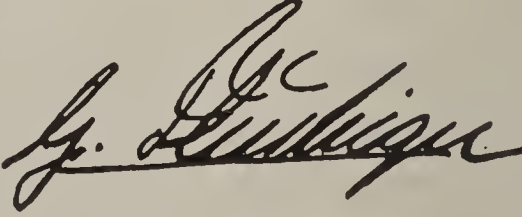

Department of Agriculture.

Section 27.18 is amended to read:

27.18 Certificates in the English language and exact form prescribed by section 27.6 (a) of the Meat Inspection Regulations are acceptable to cover the importation of meat and meat food products from the countries listed hereafter when signed by authorized officials of the countries whose names and signatures have been approved and published:

Luxemburg
Switzerland
Venezuela

The names and facsimile signatures of such foreign officials follow:

Country and name	Signature
<i>Luxemburg</i>	
Edouard Loutsch-----	
Ma cel Theisen-----	
Emile Schummer-----	
<i>Switzerland</i>	
G. Flückiger-----	
Paul Käppeli-----	
<i>Venezuela</i>	
Edward Morgan-----	